

Date: Thursday, 02/10/2008 8:24:14 AM  
 User: Julie Lecocq

## Process Sheet

|   |  |
|---|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b> : VERTICAL TUNNEL UPPER, RH            |
| <b>Job Number</b> : 42393                               |  |
| <b>Estimate Number</b> : 13613                          |  |
| <b>P.O. Number</b> :                                    | <b>Part Number</b> : D38302                                |
| <b>This Issue</b> : 02/10/2008 <b>S.O. No.</b> :        | <b>Drawing Number</b> : D38302 PROTOTYPE                   |
| <b>Prsht Rev.</b> : NC                                  | <b>Project Number</b> :                                    |
| <b>First Issue</b> : // <b>Type</b> : R&D THERMOFORMING | <b>Drawing Revision</b> : PROTOTYPE                        |
| <b>Previous Run</b> :                                   | <b>Material</b> : KYDEX 6185 (TBD)                         |
| <b>Written By</b> :                                     | <b>Due Date</b> : 17/10/2008 <b>Qty:</b> 1 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JLD 08.10.02</u>  |  |
| <b>Comment</b> : Est. Rev. A New Issue 08.09.25 DL      |  |

Additional Product

**PROTOTYPE**

Job Number:



| Seq. #: | Machine Or Operation:   | Description :                          |
|---------|---|--|
| 1.0     | HAND FINISH TH  | HAND FINISHING THERMOFORMING           |
|         |   |  |
|         | <b>Comment:</b> HAND FINISHING THERMOFORMING                                      |  |
|         | 1) Machine set up   | <i>DL 08.10.06</i>                     |
| 2.0     | HAND FINISH TH  | HAND FINISHING THERMOFORMING           |
|         |   |  |
|         | <b>Comment:</b> HAND FINISHING THERMOFORMING                                      |  |
|         | 1) Cut sheet to required blank size   | <i>DL 08.10.06</i> (X)                 |
| 3.0     | THERMOFORMING   | THERMOFORMING MACHINE                  |
|         |   |  |
|         | <b>Comment:</b> THERMOFORMING MACHINE   |  |
|         | Thermoform as per Dwg. D3830-2 and folio (FTA 9319 Prototype ) using tool DT 9319 |  |
|         | Dwg. Rev. <u>PROTOTYPE</u>  | <i>DL 08.10.06</i> (X)                 |
|         | Folio Rev. <u>A</u>   |  |
| 4.0     | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE |
|         |   |  |
|         | <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE                            |  |
|         | Visually inspect for proper formation of each part                                | <i>DL 08.10.06</i> (X)                 |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL UPPER, RH

Job Number: 42393

Part Number: D38302

Job Number:



| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|
|---------|-----------------------|--------------|

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

PROTOTYPE

KEEP IN ENG'G LAB

# 09.02.20

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



00251A today mkt /  
used per Danyl

h 09.02.24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries